: 205 SKIDTUBE "!" BEAM

Date:

Monday, 07/07/2008 8:15:42 AM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

: 40321 : 10346

P.O. Number

This Issue

: 07/07/2008

S.O. No. ; : NC

: // : 40179 Type

: SKIDTUBES

Part Number

Drawing Name

: D2596 : D2596 REV D

Drawing Number : N/A

Project Number Drawing Revision

Material

Due Date

: 14/07/2008

: D

Qty:

2 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est: D 99.02.02

Changed QA to QC, Added Step 6 and Cost

Est Rev:E 07-07-09 Incorperated DEO 9183 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D25003100

Ext'n -'I' Beam Web 4"



Comment: Qty.:

1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty 1

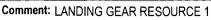
Part Number D2500-3-100

Description Extrusion

SKIDTUBES 1







- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr



3.0

HAND FINISHING1

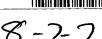
HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1





4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



Page 1

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	By Date Qty		Approval Chief Eng / Prod Mgr	Approva QC Inspector
DATE S					-			
	-							
Part No:		PAR #:	Fault Category:	NCR: Ye	s No DC	QΑ:	Date: _	
				QA	: N/C Close	ed:	Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (NO	CR)			
			Competing Action	- 0 " D			1	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B		Verification	Approval	Annessal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
						,	*				
						·	v				
							<i>.</i>				
				;							
		÷									
							-				

NOTE: Date & initial all entries

Date:

Monday, 07/07/2008 8:15:42 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "i" BEAM

Job Number: 40321

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5



6.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

FINAL INSPECTION/W/O RELEASE



Job Completion



h 08.27.08

Dart Aerospace Ltd

W /O:			WORK ORDER	CHANGES					V '- '/- '- '- '- ' ' ' ' ' '
DATE	STEP	PR	OCEDURE CHANGE	-	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No		DAD #	Foult Catagony	NCP	Voo	No DO	Δ	Data	
Part No.		PAR#:	Fault Category:	NCR: Yes No DQA: QA: N/C Closed:					
•									

NCR:			WORK OR	DER NON-CONFORMANC	E (NCR)							
		Description of NC	Corrective Action Section B			Verification	Annroyal	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
							v4.					
							181					

NOTE: Date & initial all entries

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. DETAIL SCALE 1:4 3.500 1.750 1.750 0.50 Ø0.63 REFER TO 1.750 0.50 (REF) (22 PLACES) DETAIL A DATE 07.04.17 CHECKED - 1.750 O ϖ ⋗ W/040321 P REFER TO 8.75 APPROVED DETAIL A 98.09.14 97.07.23 07.04.17 96.09.16 - 17.38 26.00 32.75 (REF) EQUAL SPACES 34.19 8.19 PITCH D2596 205 DRAWING NO ø0.63 42.38 INCORPORATED INCORPORATED NEW ISSUE /b\ 46.01 WEB 50.56 HOLE /D\ 85.59 WAS **AEROSPAC** DEO DEO 91.50 80 ONTARIO, 99.50 9183 9097 .56 **D2596 WEB** MATERIAL: MAKE FROM D2500-3-100 EXTRUSION 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 SHEET 귱 3) ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) 1 야 1 SCALE 5) DEBURR SHARP EDGES 0.010 TO 0.020 1:20

Dart Ae	rospace L	td		4					
N/O:		·····	V	VORK ORDER CHANGES					
DATE	STEP	STEP PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
, : *·			4	×					
Part No		PAR #:	Fault Ca	tegory: NC	R: Yes	No DQ	A:	Date:	
		·			QA: N	I/C Close	d:	Date:	
NCR:		,	WORK OR	DER NON-CONFORMANCI	E (NCF	R)			
		Description of NC		Corrective Action Section B		Verification Approva			Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspecto
•					-				

NOTE: Date & initial all entries

